

Work Order ID 56595

Tuesday, March 02, 2010 8:27:57 AM

Page 1

Item ID: D3762-041

Accept

Revision ID:

Item Name: Front Leg Fitting Assembly

Start Date: 3/2/2010 Start Qty: 6.00

Required Date: 3/16/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

mf

Date: 10-3-2

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3762

Rev A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-assemble as per dwg D3762 using locating pins DT9014 and tack weld parts in place

2- take pins out before welding

3-weld as per dwg D3762 per QSI004

Alum. rod Batch: M112860

Cpl 10-03-17

Cpl 10-03-17

Atb ->

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3762-041 PAR #: _____ Fault Category: Large Fats NCR: Yes No DQA: [Signature] Date: 10/03/19
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/03/24

NCR: <u>56595</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/03/19</u>	<u>#110</u>	<u>Qty x2 Parts have cracks in D3762-3 From welding R.L. Process</u>	<u>[Signature]</u>	<u>Scrap + Destroy no Replace QM x2</u>	<u>[Signature]</u> <u>10/03/19</u>	<u>[Signature]</u> <u>10-3-19</u>	<u>[Signature]</u>	<u>S</u> <u>10/03/19</u>

NOTE: Date & initial all entries

Work Order ID 56595

Tuesday, March 02, 2010 8:27:57 AM



Page 2

Item ID: D3762-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Leg Fitting Assembly

Start Date: 3/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 3/16/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

PD 10.03.13

x4 x3

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. 10/1/19

(x4) (x2)

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

MS 10/03/20

(x4) Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 56595

Tuesday, March 02, 2010 8:27:57 AM



Page 3

Item ID: D3762-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Leg Fitting Assembly

Start Date: 3/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 3/16/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

PLC03/22 (4)

160

Identify as per dwg & Stock Location: 251

0.00



Packaging

Memo

0.00

Packaging

PLC03/22 (4)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24

PLC0-3-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 02, 2010 8:27:56 AM

Page 1

Work Order ID: 56595



Parent Item: D3762-041



Parent Item Name: Front Leg Fitting Assembly

Start Date: 3/2/2010

Required Date: 3/16/2010

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3762-3		Manufactured	No			100	Each	2.0000	6.0000			



Tube



Pl 10.03.17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

54370

D3762-1

Manufactured

No



Fitting

110

2

2

Each

0.0000

12.0000



B56753 → ④ Pl

② Pl

B56754 → ⑥ Pl 10.03.17
⑫

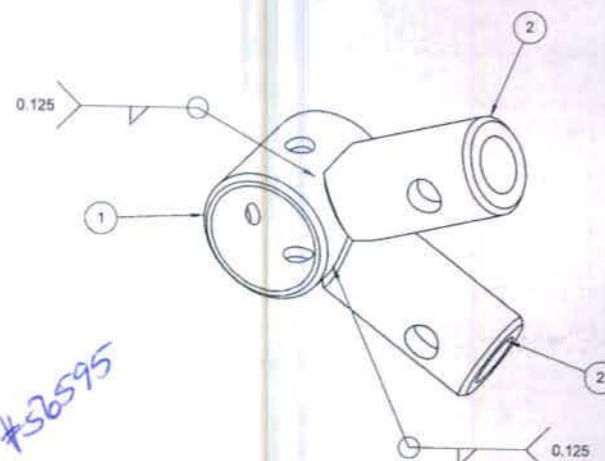
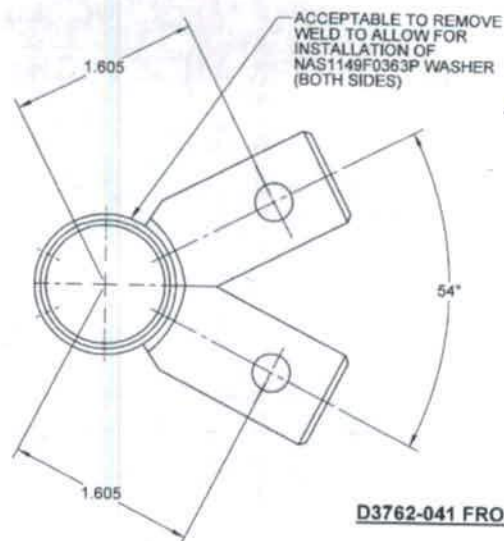
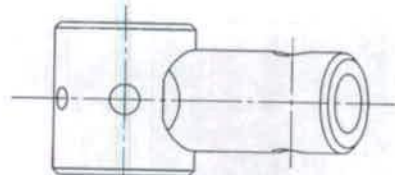
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

D3762-041 FRONT LEG FITTING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

RELEASED
08-06-16/11/17

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3762	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FRONT LEG FITTING	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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